
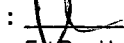


Date: Thursday, 10/08/2006 9:58:02 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350 SKIDTUBE ASSEMBLY RH
Job Number : 28114	
Estimate Number : 10268	
P.O. Number : N/A	Part Number : D350636014
This Issue : 10/08/2006 S.O. No. : N/A	Drawing Number : D2750 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : D
Previous Run : 27353	Material : N/A
Written By : 	Due Date : 05/09/2006 Qty: 1 Um: Each
Checked & Approved By : 	
Comment : Est Rev:H 02.09.25 Rearranged procedure steps KJ Est Rev:I 05.12.08 Rearranged procedure steps EC Est Rev:J 06.03.30 Per rev. D EC	

Additional Product

Job Number:




Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------

**Comment:** DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-014 CHG 002

KJ 06-08-30 

2.0	D26003BENT	Extrusion Bent
-----	------------	----------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description


Batch

1

D2600-3-Bent

Extrusion (Bent)

B26787

Pm 06-08-15(1) 

3.0	D2744	Fwd Cap
-----	-------	---------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch:

B25839

BE 06-08-15(1) 


4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------

**Comment:** LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 & DT8864 drilling holes labelled "B" only.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut

} Pm 06-08-15(1) 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/08/2006 9:58:02 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 28114

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

as per dwg D2750.

4-Drill pilot holes for Detail B using DT8330

5-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.250" ***Make sure that wearplate holes are on bottom of tube*****

6-Open up holes of Detail A to 0.250" (total of 2 holes per side)

7- Countersink all fwd wearshoe holes (total of 19 holes per side) DO NOT C'SINK THE LAST AFT HOLES (total of 2 per side for blade fitting) as per dwg D2750.

8-Countersink Detail A as per dwg D2750.

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod *M100660 BE 06-08-15*

10-Grind welds flush as per Dwg D2750 *BE 06-08-15*

5.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

DP 6-8-15

PD 06-08-15

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Pm 06-08-15

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 6-8-15

8.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

Batch: *B27665 BE 06-08-17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date: Thursday, 10/08/2006 9:58:02 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 28114

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D34901

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: B27385 BE 06-08-18

10.0

D34905

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: B27834 BE 06-08-18

11.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch: B26208 BE 06-08-18

12.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes for Detail B, "hole size W" and blade fitting location holes to 0.500" (total of 9 holes per side) as per dwg D2750. fm 06-08-15

2-Open up holes "size X" (total of 4 holes per side) as per dwg D2750 fm 06-08-15

3-Open up holes of Detail V & Detail C to 0.625" (total of 8 holes per side) as per dwg D2750. fm 06-08-15

4-Chamfer holes of Detail V, Detail C, hole size "W" and "X" per dwg D2750 (welding instructions on sheet 5) fm 06-08-16

5-Deburr and blow out all chips from inside of tube fm 06-08-16

6-Bond web D2739 in place as per QSI 015

A/R

Sikaflex-291

batch:

m/101855

BE 06-08-17

exp. date:

07/02

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 5)

A/R

Aluminum Rod

batch:

m/100660

BE 06-08-18

8-Grind welds flush as per Dwg D2750 fm 06-08-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 28114

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

9-Spot face ground handling holes section J-J (total of 4 places per side) as per dwg D2750 *pm '06-08-23*

10-Deburr holes *pm '06-08-23*

13.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and work to Step 20

PD 06-08-25 (1)

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3 *pm 06-08-29*

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

FC 06-08-29 (1)

16.0

NAS1330S3KB166

INSERT



Comment: Qty.: 42.0000 Each(s)/Unit Total: 42.0000 Each(s)

INSERT

Batch: *m/01368*

DL 06/08/29 (1)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts as per dwg D2750

DL 06/08/29 (1)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Inserts

DL 08 29 (1)

19.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Wearpad

Batch: *B27169*

DL 06/08/29 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 28114

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B27074

21.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B25330

22.0

D2746

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B27485

23.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: B26140

24.0

D3488042

BLADE FITTING ASSEMBLY, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: B26839

25.0

D3492041

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B27191

DL 06/08/29 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/08/2006 9:58:03 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 28114

Part Number: D350636014

Job Number:



Seq. #:	Machine Or Operation:	Description :
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26.0	D3492045	PLUG ASSEMBLY
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B27192

27.0	AN635A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bolt

Batch:

28.0	AN960JD816	1/2" washer, Alum
------	------------	-------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch:

29.0	MS21083N8	Nut
------	-----------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Nut

Batch:

30.0	AL641032225	Insert
------	-------------	--------



Comment: Qty.: 46.0000 Each(s)/Unit Total: 46.0000 Each(s)

Insert

Batch:

31.0	AN960JD40L	Washer
------	------------	--------



Comment: Qty.: 42.0000 Each(s)/Unit Total: 42.0000 Each(s)

washer

Batch:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 28114

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

~~AN3C5A~~ AN3C5A DV

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

Bolt

Batch: M101124 M101648

33.0

~~AN3C6A~~ AN3C6A DV

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M101124 M101291

34.0

AN3C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Batch: M101124

35.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Batch: M19514

36.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BOLT

Batch: M102180

37.0

AN960C10L

washer



Comment: Qty.: 46.0000 Each(s)/Unit Total: 46.0000 Each(s)

washer

Batch: M100186

38.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: M100186

a.m. 06/10/13

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/08/2006 9:58:03 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 28114

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

NUT

Batch: M19185

40.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

NUT

Batch: M100196

41.0

NAS1515H3L

WASHER



Comment: Qty.: 46.0000 Each(s)/Unit Total: 46.0000 Each(s)

WASHER

Batch: 21X M19099, 25X M101340

42.0

NAS1515H8L

WASHER



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

WASHER

Batch: M100187

OL 06/08/29 ①

43.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Assemble tube hardware as per dwg D2750

Sika Alex

2-Inspect For Foreign Objects

3-Spray inside of tube with "LPS-3" batch: M101915

4-Install blade fitting D3488-041, wearshoe

SIKA FLEX 241

BATCH: M101855

EXP DATE 08-07

5-Coat all exposed fasteners with "LPS Procyon" batch: M17168

a.m 06/10/23 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 28114

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

44.0

QC5

INSPECT WORK TO CURRENT STEP



ml ob D 23



(1)

Comment: INSPECT WORK TO CURRENT STEP

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

46.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Blade

Batch: *B27968*

47.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: *M100186*

48.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch: *M100186*

49.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: *M100262*

50.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: *M100187*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 28114

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

51.0

D34931

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: *B27895*

Rec'd 10/26 (1)

52.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

0306/10/26 (1)

53.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-014

Perve

Rec'd 10/26 (1)

54.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Doc'd 10/27

Job Completion



U Doc'd 10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
06-02-07

REFERENCE ONLY

DESIGN <i>P44</i>	DRAWN BY <i>P44</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. D SHEET 1 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740	
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133/9157	

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
5	5	5	5	D2648-3	WEARPAD
1	1	1	1	D2656-13	WEARSHOE
1	1	1	1	D2656-35	WEARSHOE
1	1	1	1	D2746	WEARSHOE
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
2	2	2	2	AN8C21A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
4	4	4	4	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
3	3	3	3	MS21083C8	NUT
42	42	42	42	NAS1330S3KB166	INSERT
46	46	46	46	NAS1515H3L	WASHER
12	12	12	12	NAS1515H8L	WASHER

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DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D2750	REV. D SHEET 2 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

RELEASED
06.02.07

GENERAL NOTES:

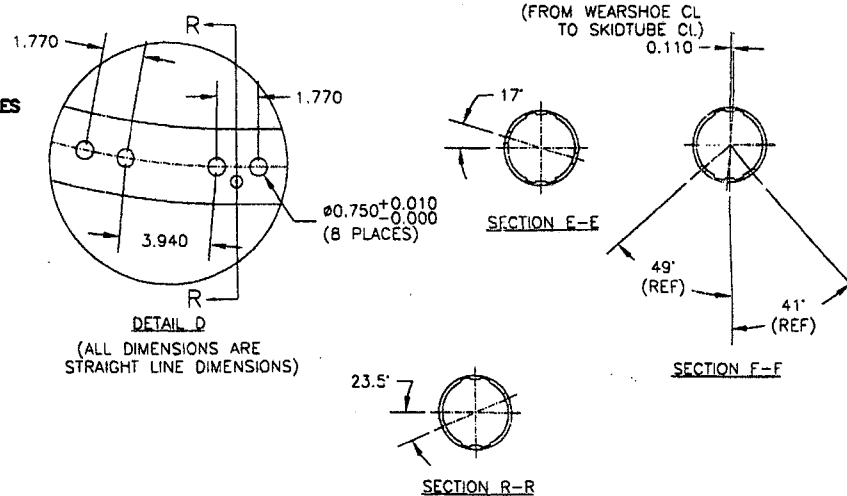
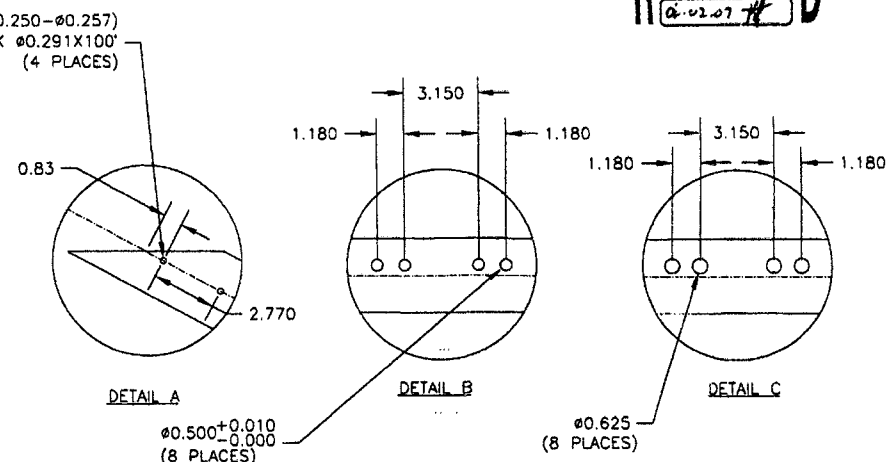
REFERENCE ONLY

1. ALL DIMENSIONS ARE IN INCHES
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E, F-F, AND R-R.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL NAS1330B3KB166 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'E' SIZE HOLES ($\emptyset 0.250$ - $\emptyset 0.257$) FOR WEARSHOE INSERTS. C'SINK $\emptyset 0.391 \times 100^\circ$ AND INSTALL INSERTS
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3-5A/AN3-7A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12. APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES

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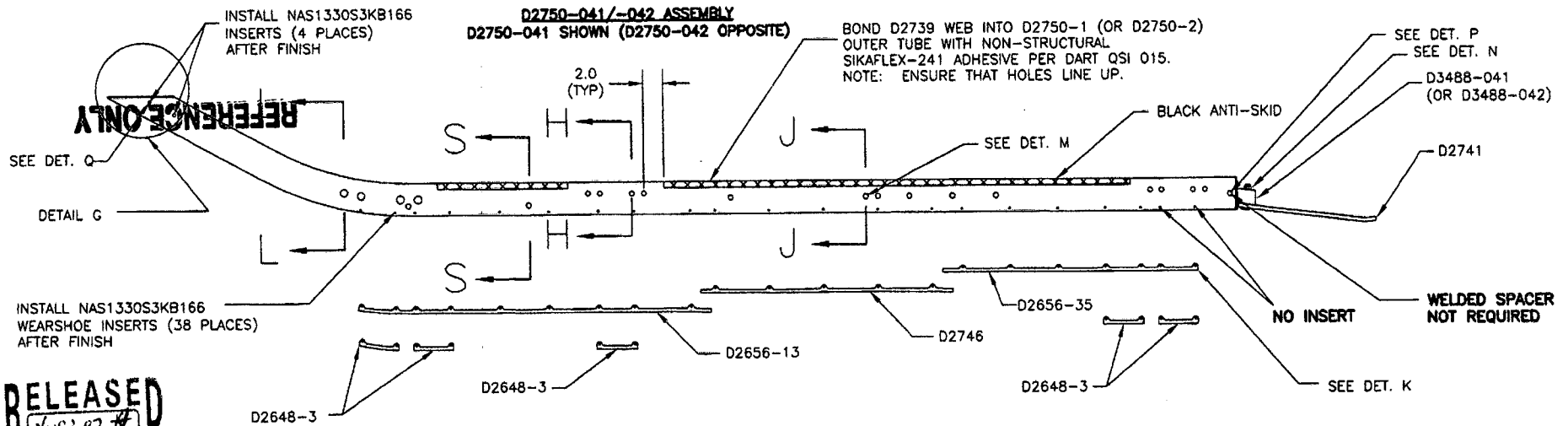
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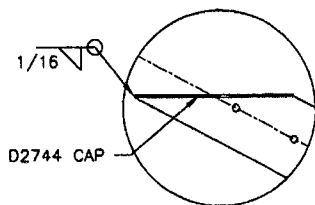
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					PORT HADLOCK, MA	
CHECKED	PH	APPROVED	PH	DRAWING NO.		REV. D
				02750		SHEET 3 OF 5
DATE	06.01.05			350 SKIDTUBE ASSEMBLY		SCALE
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D2750-041/-042 ASSEMBLY
D2750-041 SHOWN (D2750-042 OPPOSITE)

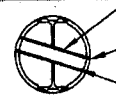
BOND D2739 WEB INTO D2750-1 (OR D2750-2)
 OUTER TUBE WITH NON-STRUCTURAL
 SIKAFLEX-241 ADHESIVE PER DART QSI 015.
 NOTE: ENSURE THAT HOLES LINE UP.



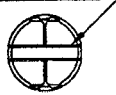
DETAIL G



SECTION H-H

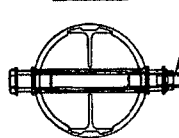


SECTION J-J



- WELDING INSTRUCTIONS**
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D2743 SPACER
 3. WELD INTO PLACE
 4. GRIND FLUSH
 5. DRILL OUT SPACER TO Ø0.484
 6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

DETAIL M



- AN6-44A BOLT (1)
 D2745 BUSHING (2)
 NAS1515H8L WASHER (2)
 MS21043-6 NUT (1)
 (4 PLACES)
NOTE: INSTALL WASHER BETWEEN SKIDTUBE AND BUSHING

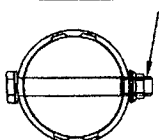
DETAIL K



USE AN3C7A BOLTS
 FOR INSTALLING AFT
 D2648-3 WEARPAD
 (4 PLACES)

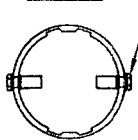
- AN3C5A BOLT (1)
 AN960JD10L WASHER (1)
 NAS1515H3L WASHER (1)
 (38 PLACES)

DETAIL P



- AN8C35A BOLT (1)
 AN960C816L WASHER (2)
 NAS1515H8L WASHER (2)
 MS21083C8 NUT (1)

DETAIL Q

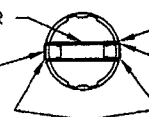


- AN3C6A BOLT (1)
 AN960C10L WASHER (1)
 NAS1515H3L WASHER (1)
 (4 PLACES)

SECTION I-I

D3490-3 SPACER

Ø0.750 HOLES ONLY

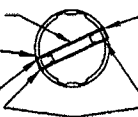


D3492-043 PLUG ASSEMBLY

SECTION S-S

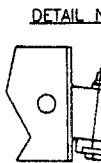
D3490-1 SPACER

Ø0.500 HOLES ONLY



D3492-041 PLUG ASSEMBLY

- WELDING INSTRUCTIONS**
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES OR INSERT D3490-3 SPACER (4 PLACES) INTO Ø0.750 HOLES
 3. WELD INTO PLACE
 4. GRIND FLUSH
 5. INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER OR INSERT D3492-043 PLUG ASSEMBLY (8 PLACES) INTO D3490-3 SPACER ON BOTH ENDS

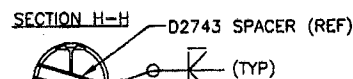
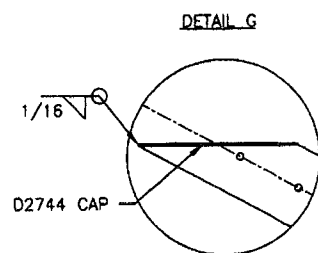
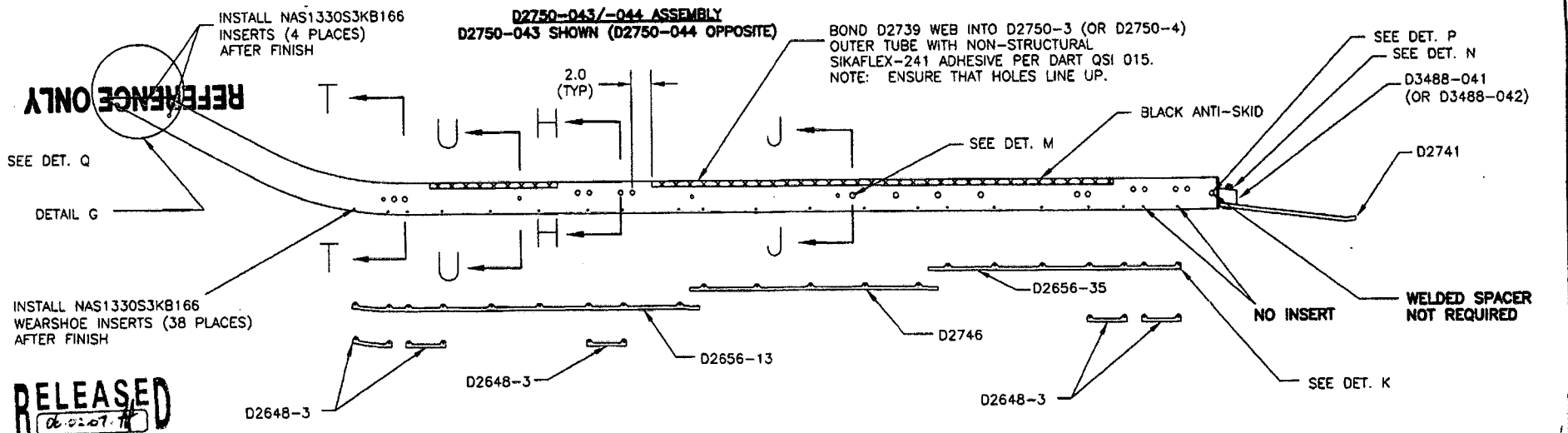


- AN8C21A BOLT (1)
 AN960JD816L WASHER (1)
 NAS1515H8L WASHER (1)
 MS21083C8 NUT (1)
 (2 PLACES)

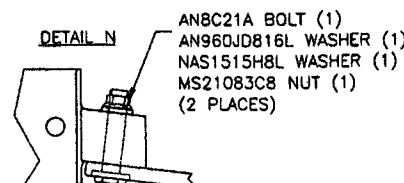
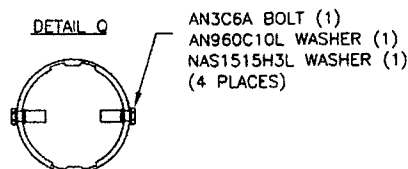
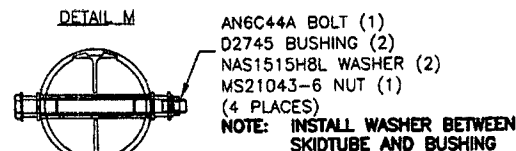
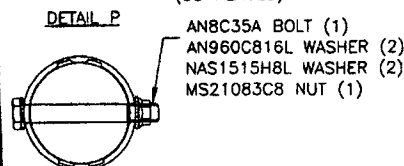
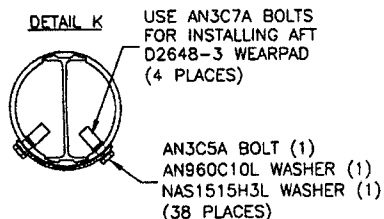
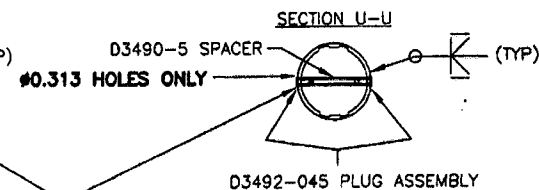
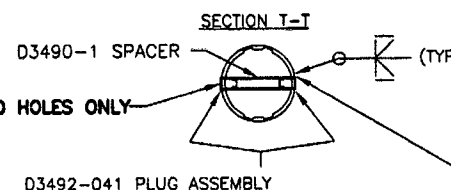
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- SECTION J-J**
- WELDING INSTRUCTIONS**
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D2743 SPACER
 3. WELD INTO PLACE
 4. GRIND FLUSH
 5. DRILL OUT SPACER TO Ø0.484
 6. SPOT FACE Ø0.750 (SECTION J-J ONLY)



- WELDING INSTRUCTIONS**
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D3490-5 SPACER (4 PLACES) INTO Ø0.313 HOLES OR INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES
 3. WELD INTO PLACE
 4. GRIND FLUSH
 5. INSERT D3492-045 PLUG ASSEMBLY (8 PLACES) INTO D3490-5 SPACER OR INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER ON BOTH ENDS

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DATE	06.01.05	TITLE	350 SKIDTUBE ASSEMBLY	SCALE	1:20